

Date: Thursday, 6/15/2006 1:50:18 PM  
User: Kim Johnston

## Process Sheet

SLIP 2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
Job Number : 27579  
Estimate Number : 10256  
P.O. Number : N/A Part Number : D22303  
This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D2230 REV F  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : F  
Previous Run : 26593 Material : N/A  
Due Date : 7/5/2006 Qty: 200 Um: Each  
Written By : *See comment below*  
Checked & Approved By : *06.06.15*  
Comment : Est D 90.05.18 Added inspection level 8, and removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion

D2423

Batch: B23779

*B23779 En 06/07/10 x60*  
*J-F 06/06/19*  
*(204)*

2.0 BAND SAW BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: B23779

*B23779 En 06/07/10 x60*  
*J-F 06/06/19*  
*(204)*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

*R/O 1521*  
*C206/20/06 (204)*

4.0 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

5.0



Comment: SECOND CHECK

*Machine per drawing D2230 Rev.F*  
*Receive + Inspect for transit damage*  
*2607.10 (100)*





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Drawing Name: MOUNTING LUG

Job Number: 27579

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



*A/A*

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

*SA 06.07.18*

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*SAD 06.07.18  
SAD 06.07.10*

*(104)*

8.0 QC3 INSPECT WORK TO CURRENT STEP



*E*

Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*SC 06/07/10  
DU*

*(104)*

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

*20 6/7/20*

*(104)*

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *54371*

*06/07/20 104*

*MF 07/07/20 104*

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*A 06.07.20*

Job Completion



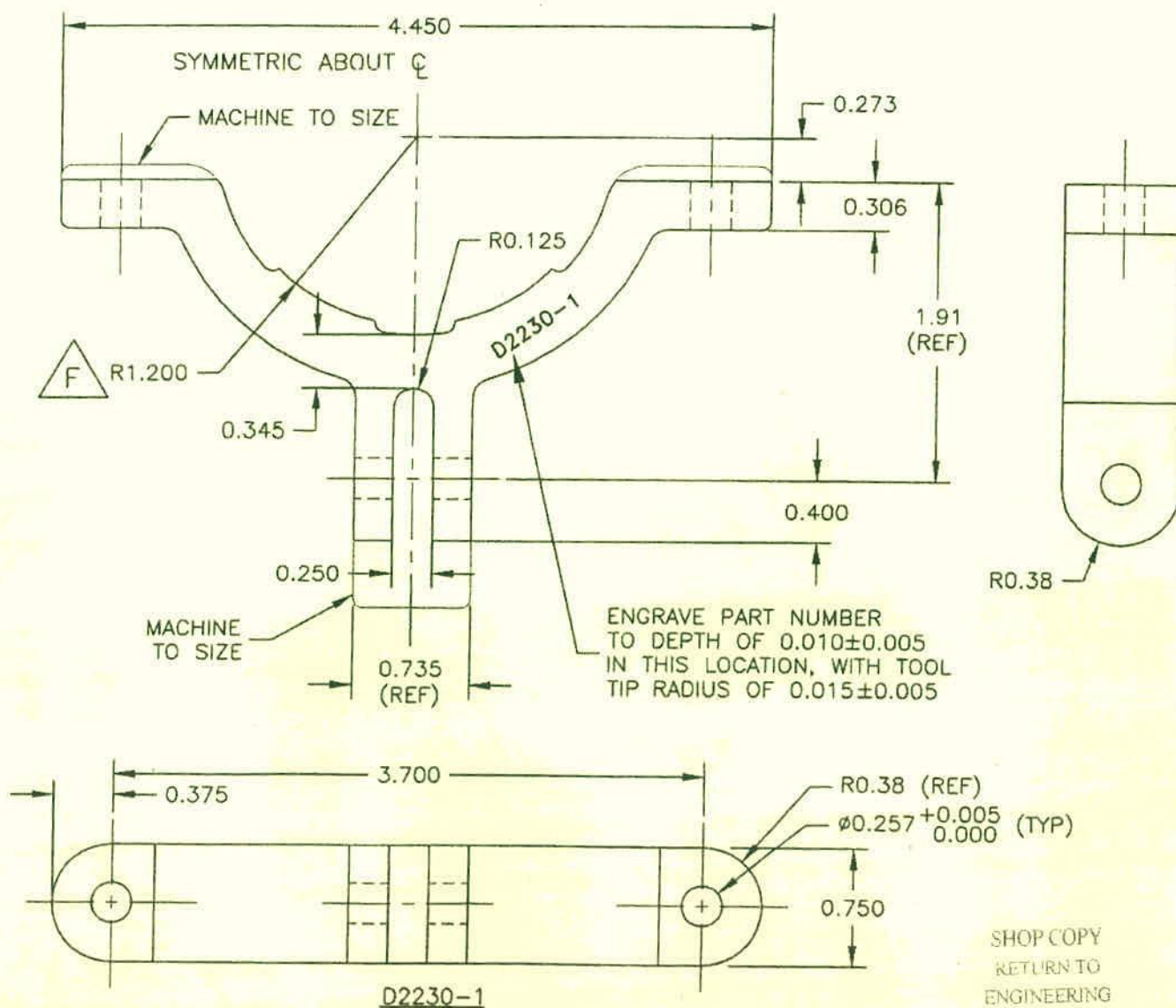
*u 06.07.20*





**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 27579

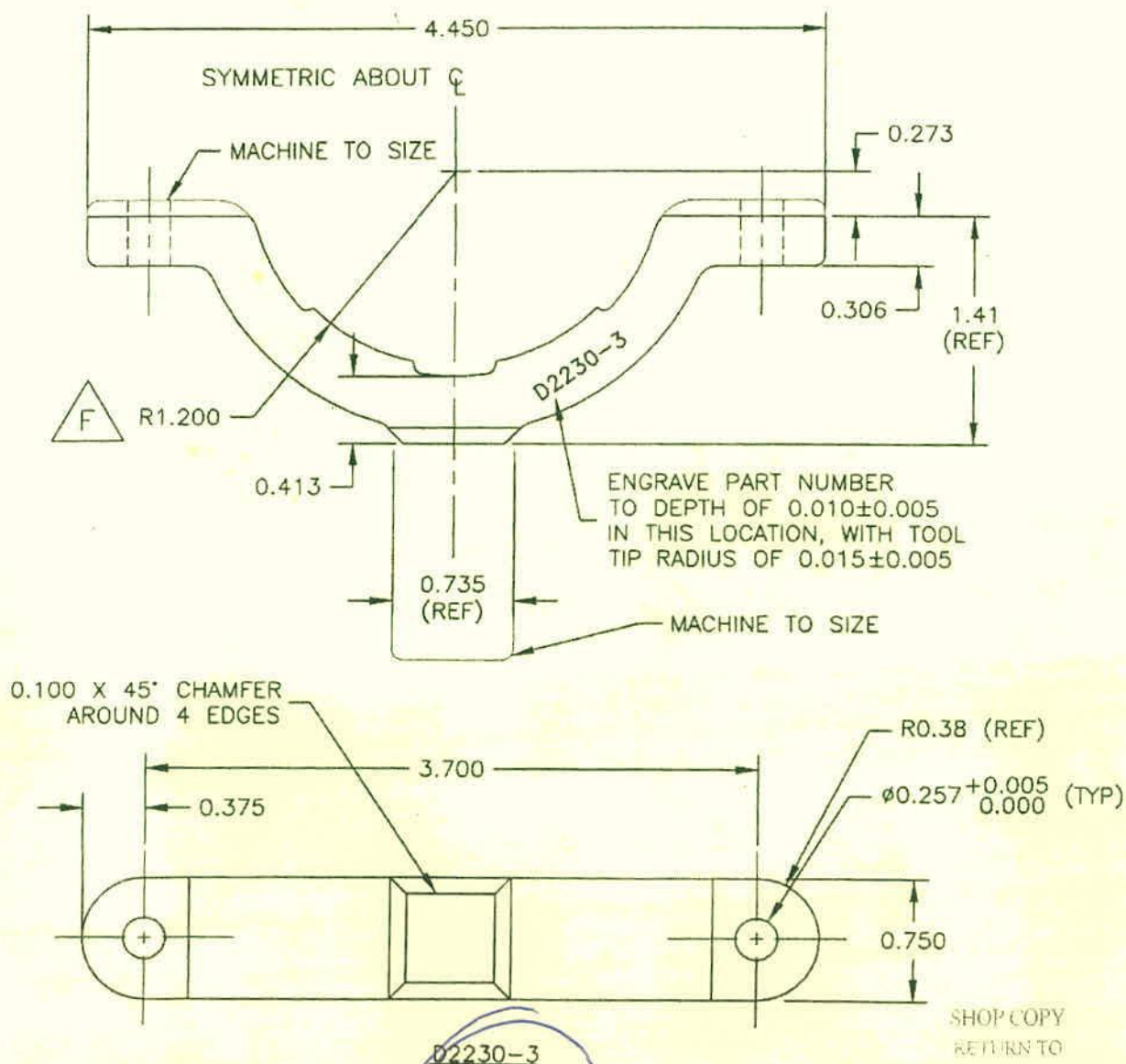






DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. \_\_\_\_\_







## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

104

D 2230-3

Mounting Lug

1521

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

*Shigi Regula Walz*  
Shigi (Regula) Walz

Vankleek Hill, July 12, 2006



